

Date: Monday, 3/19/2007 4:39:00 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LEFT ARM WELDMENT
Job Number	: 31304		
Estimate Number	: 11871		
P.O. Number	: N/A	Part Number	: D33549
This Issue	: 3/19/2007 S.O. No. : N/A	Drawing Number	: D3354 REV AB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: AB
Previous Run	: 29905	Material	: N/A
Written By	:	Due Date	: 3/26/2007
Checked & Approved By	: <u>07.03.20</u>	Qty:	6 Um: Each
Comment	: est. rev.A 06.01.14 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1020TR1250W219	Seamless Round Tubing
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Comment: Qty.: 0.2405 f(s)/Unit Total : 1.4427 f(s)
 Seamless Round Tubing
 AISI 1020 1.25" OD x .219" wall batch: M19343

07/03/24

(6)

2.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE
 1-Turn as per dwg D3354

2- Deburr

07/03/26

(6)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 1-Drill hole, mill flat & c'sink as per dwg D3354
 2- Mill angle on end as per dwg D3354

3- Deburr

07/03/26

(6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/03/31

(6)

5.0	QC8	SECOND CHECK
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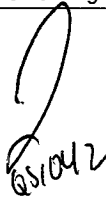

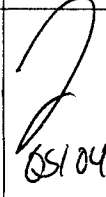

Comment: SECOND CHECK

07/03/31

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/04/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
31/03/07	3.0	Angle of 18° Machined on Rang Side (operator error)	 05/04/02	Destroy and Replaced.	07/03/31 DSP	 07/03/31	 05/04/02	 07/03/31

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:39:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 31304

Part Number: D33549

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 04/04/02 @

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

04/04/04

Job Completion



U 07.04.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

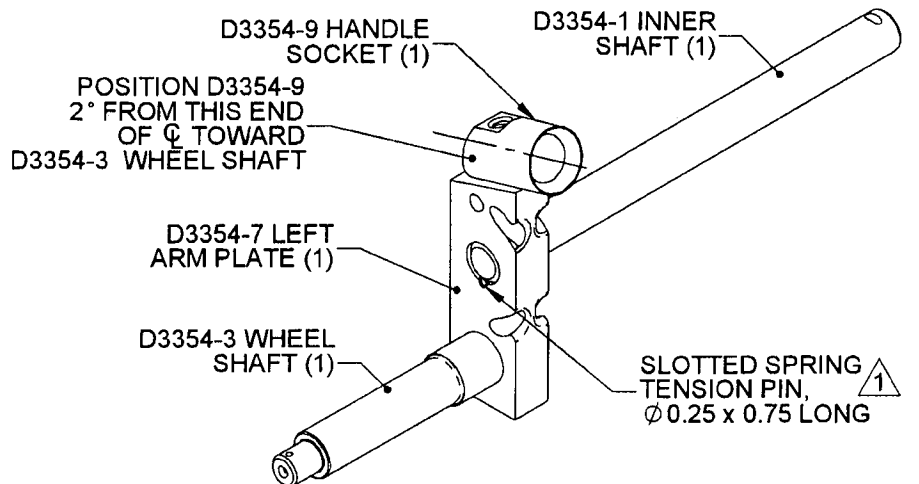
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

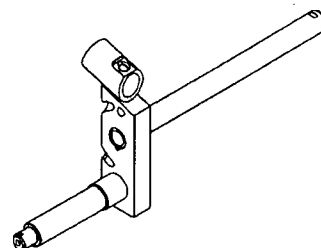


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. LEFT ARM WELDMENT	REV. B SHEET 1 OF 7
DATE 07.02.02	TITLE D3354	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	

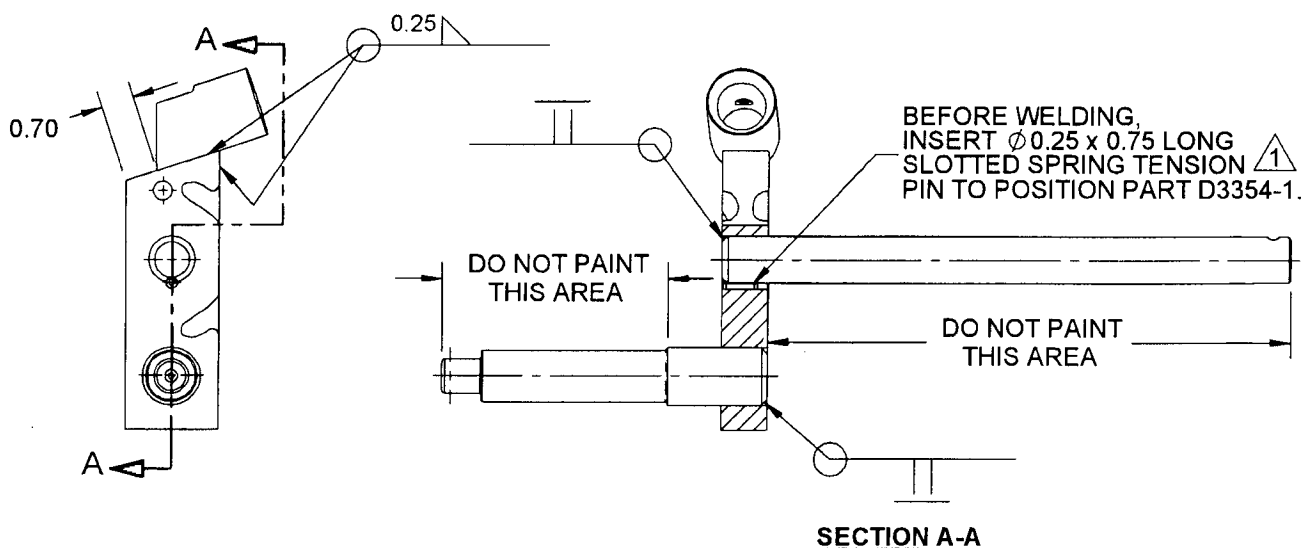
RELEASED
07.02.02



D3354-041 LEFT ARM WELDMENT



D3354-042 MIRROR ARM WELDMENT



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

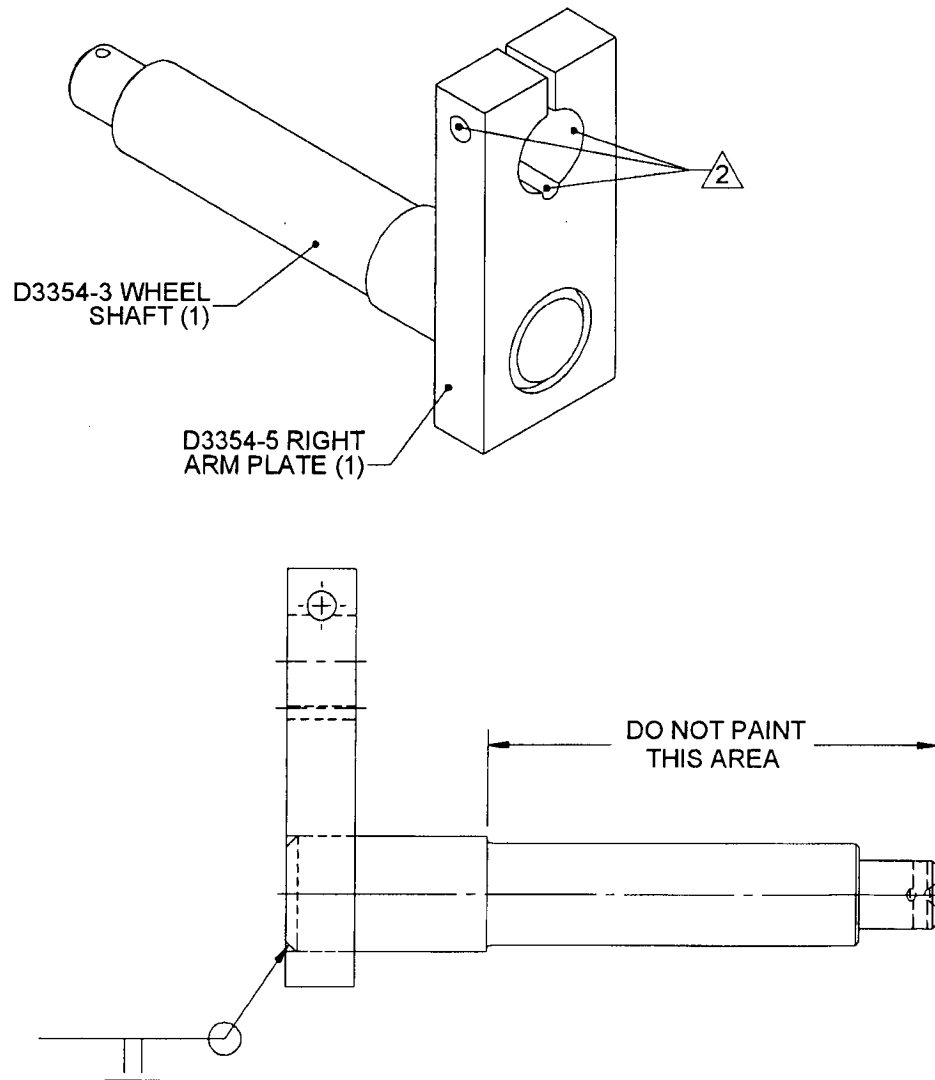
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
[Signature] 07.02.02**D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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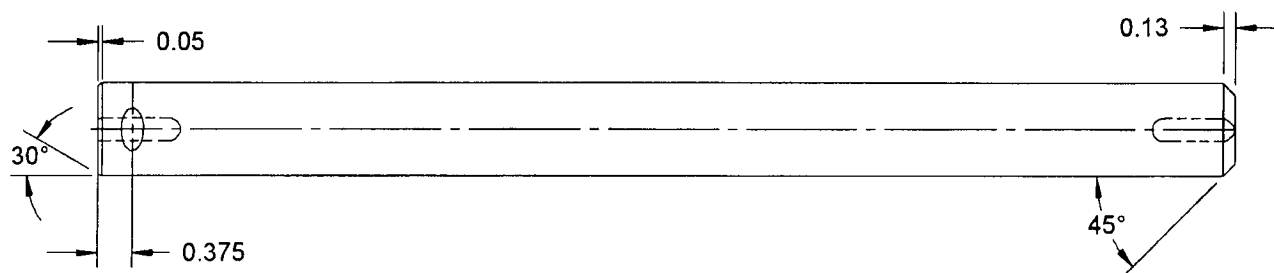
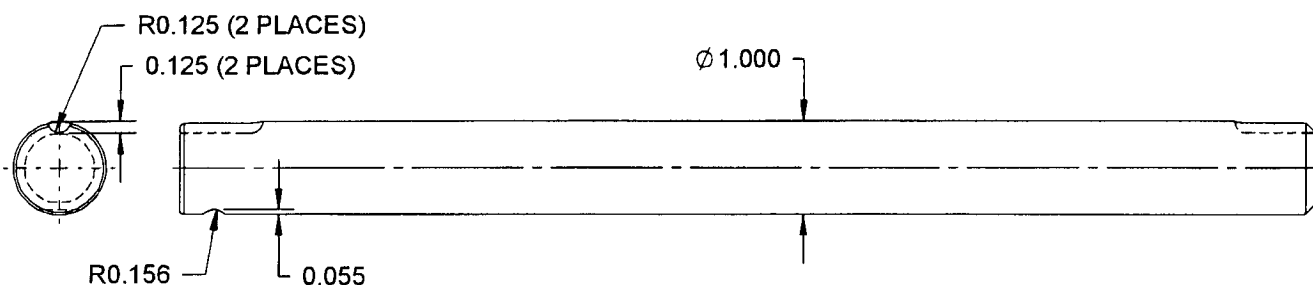
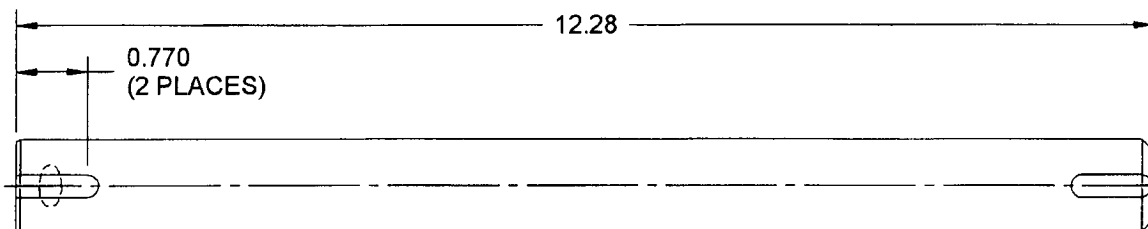
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
[Signature] 07.02.02



D3354-1 INNER SHAFT

NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-03
OR UNS# G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

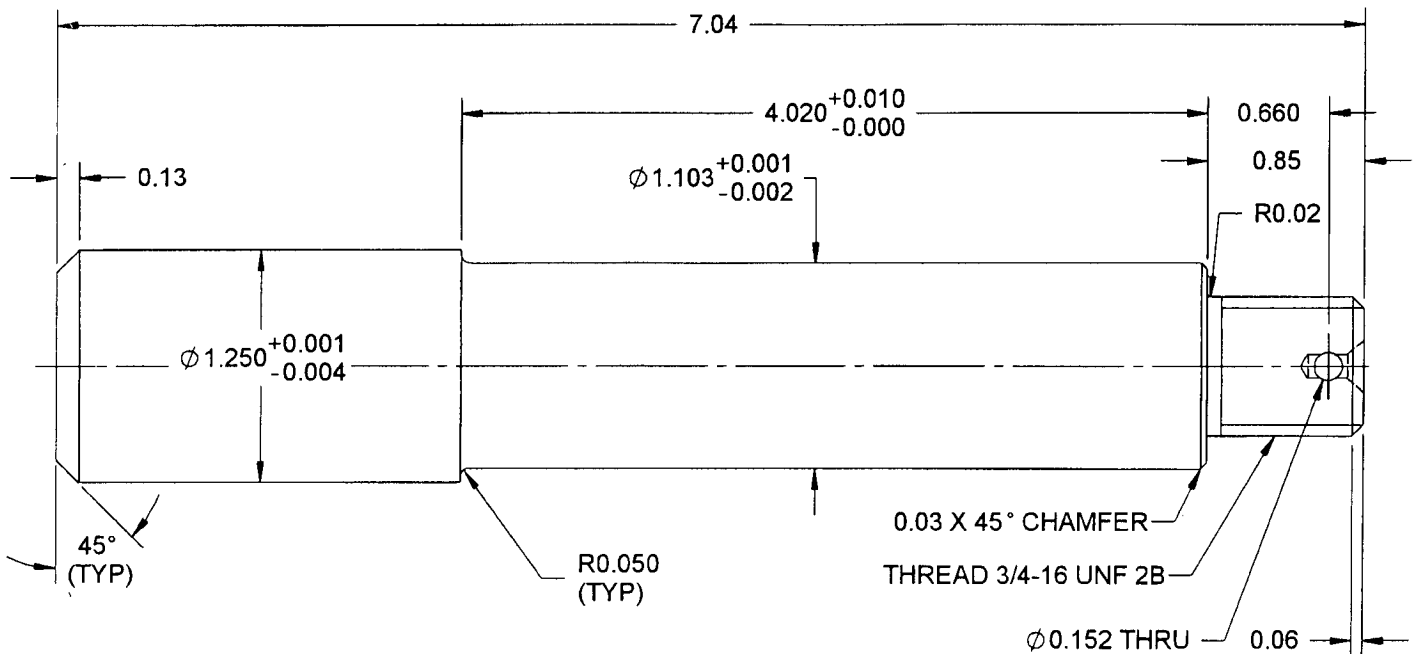
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
[Stamp] 07.02.02**D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

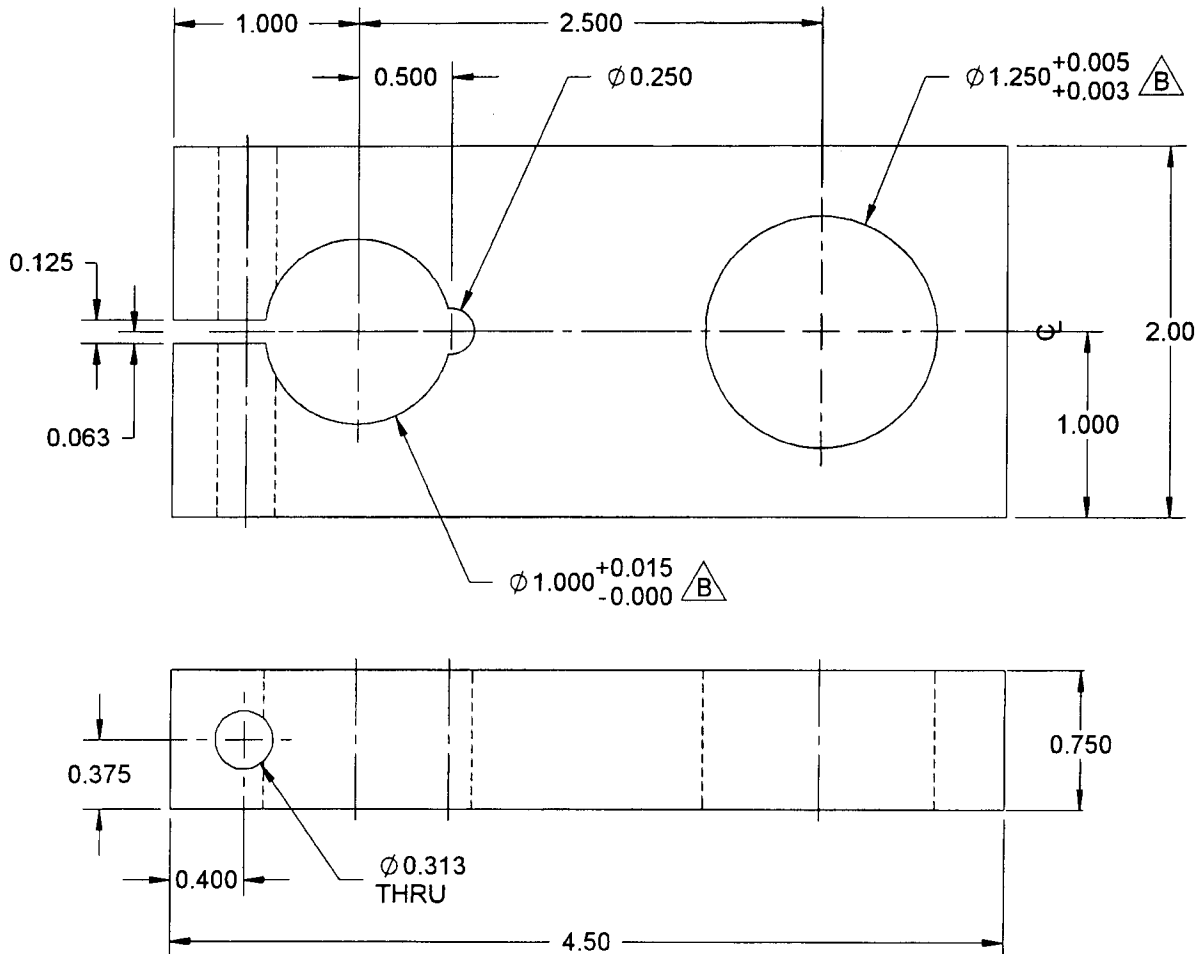
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
[Signature] 07.02.02**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

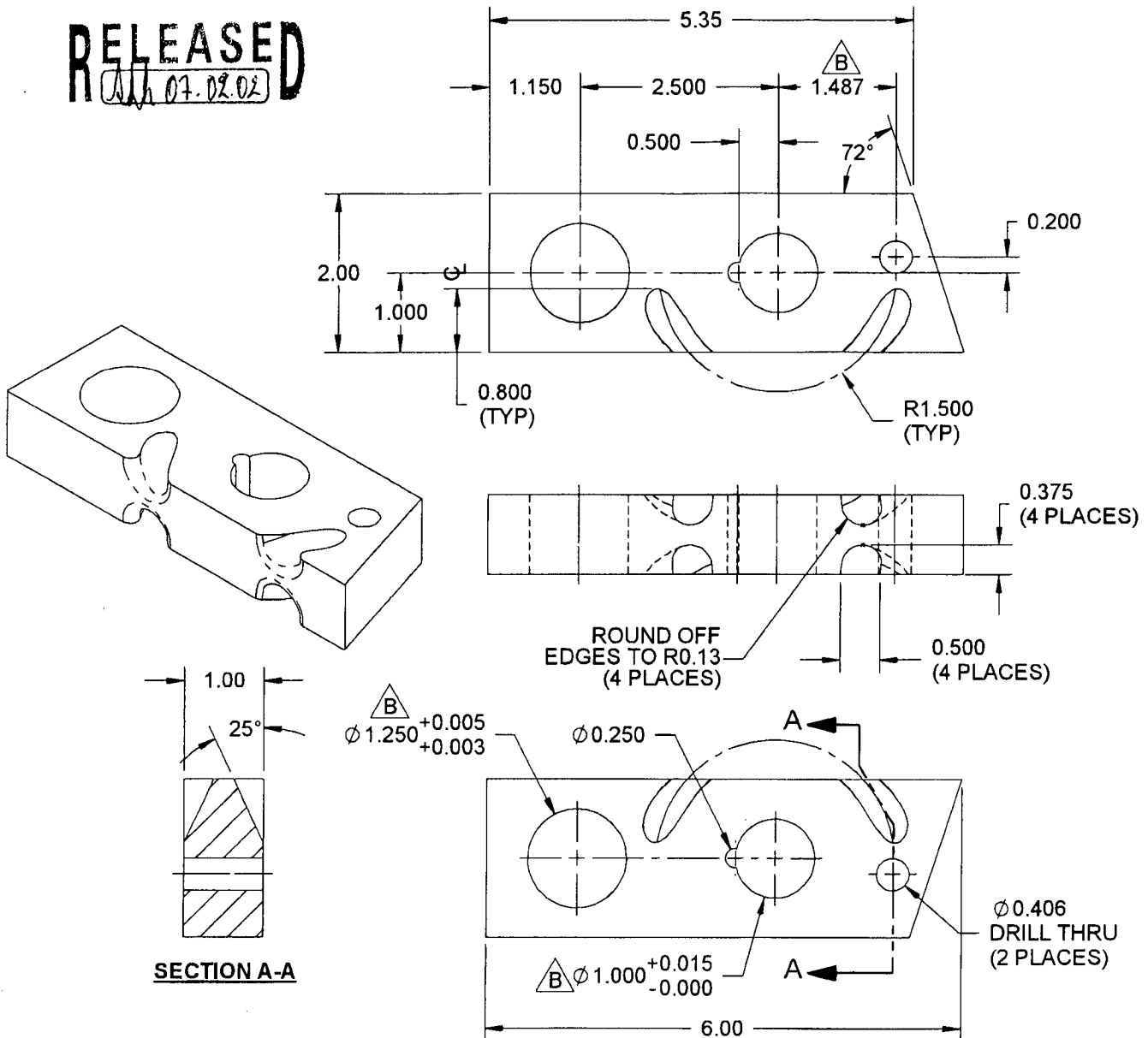
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
[Signature] 07.02.02**D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

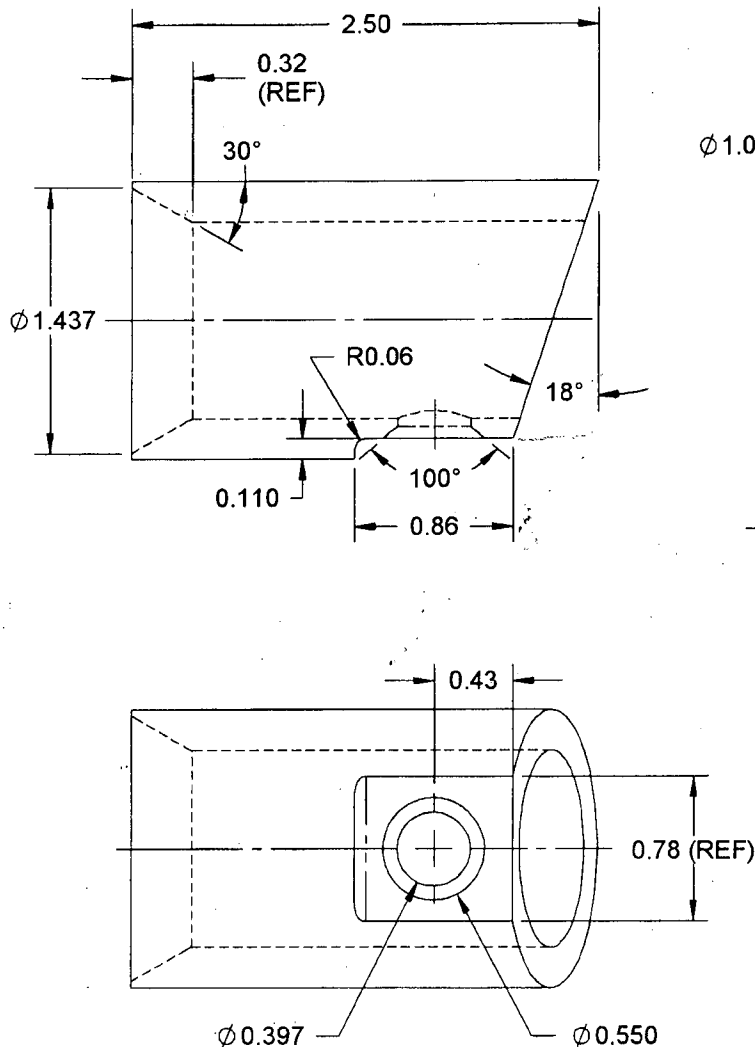
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

**RELEASED**
07-02-02**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR
ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
(REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DART AEROSPACE LTD		Work Order: 31304
Description: Handle Socket		Part Number: D33549
Inspection Dwg: D3354 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 1.50$	± 0.030	1.505	✓			
B $\phi 1.062$	± 0.010	1.060	✓			
C 0.219 (Ref)	± 0.030	0.220	✓			
D 2.50	± 0.030	2.498	✓			
E 0.32 (Ref)	± 0.030	0.325	✓			
F $\phi 1.437$	± 0.010	1.445	✓			
G 30°	$\pm 1/2^\circ$	30°	✓			
H 18°	$\pm 1/2^\circ$	18°	✓			
I 0.86	± 0.030	0.86	✓			
J 0.110	± 0.010	0.112	✓			
K 100°	$\pm 1/2^\circ$	100°	✓			
L R0.06	± 0.030	0.060	✓			
M 0.43	± 0.030	0.429	✓			
N $\phi 0.397$	$+0.006 -0.001$	0.399	✓			
O $\phi 0.550$	± 0.010	0.555	✓			
P 0.78 (Ref)	± 0.030	0.795	✓			
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: DTP	Audited by: J.L	Prototype Approval: N/A
Date: 07/03/26	Date: 07/03/31	Date: N/A

Rev	Date	Change	Revised by
		New Issue	KJ/RF